



Dart Hawkesbury  
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**D3681-1**  
**Job Sheet 168675**



Part No: D3681-1

Job Qty: 230 ea

Part Name: Spacer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 11/21/17

Job Tracking No:

Due Date: 12/3/17

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG REV A IPP Rev A new issue 07-10-30 DD verified by:EC IPP Rev:B Ecn 1056 Rev A dwg DD IPP Rev:C add seq 125 DD 10.05.03 verified by:EC

Ship Via:

### Bill of Materials

### Job Routing

| Op No | Operation          | Qty     | Start Date | Due Date | Standard  |         | Workcenter/Supplier   |           | Sign-off |
|-------|--------------------|---------|------------|----------|-----------|---------|-----------------------|-----------|----------|
|       |                    |         |            |          | Setup hrs | Run Hrs | Workcenter / Supplier | Lead Time |          |
| 90    | Start up Operation | 230 Ea  |            | 12/2/17  | 0.00      | 0.00    | Start Up Machining    |           |          |
| 100   | Hardinge           | 230 pcs |            | 12/2/17  | 0.06      | 6.08    | Hardinge              |           |          |
| 120   | QC                 | 230 pcs |            | 12/2/17  | 0.00      | 0.00    | QC8                   |           |          |
| 125   | Skidtubes          | 230 pcs |            | 12/3/17  | 0.00      | 1.64    | Skidtubes             |           |          |
| 130   | Packaging          | 230 pcs |            | 12/3/17  | 0.00      | 0.00    | Packaging3            |           |          |
| 140   | QC21-SA            | 230 Ea  |            | 12/3/17  | 0.00      | 0.00    | QC21                  |           |          |

Part Op 100 - 1-TURN AS PER FOLIO FA711& DWG D3681

Descriptions: 125 - 1- clean crossbolt spacer with ultra bright aluminum cleaner before storing.

130 - \*\*\*STOCK IN SKIDTUBE CELL\*\*\*

### Job Allocations

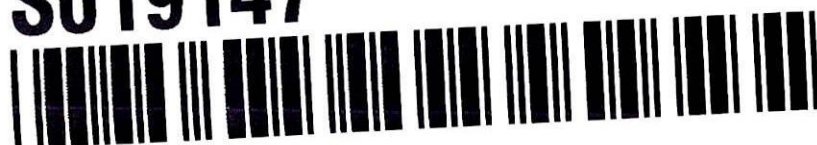
| Operation             | Component Part      | Required | Inventory | Allocated | Std Qty |
|-----------------------|---------------------|----------|-----------|-----------|---------|
| 90-Start up Operation | M6061T6T0.3125W.058 | 78       | 117       | 0         | 0       |

### Part Specifications

| Spec No | Description | Target/Tolerance               | Limits         | Type | Special Comments |
|---------|-------------|--------------------------------|----------------|------|------------------|
| 1       | Spacer      | 0.313inches $\pm$ 0.010        | 0.323<br>0.303 |      |                  |
| 2       | Spacer      | 0.197inches $\pm$ 0.010        | 0.207<br>0.187 |      |                  |
| 3       | Spacer      | 4.080inches + 0.030<br>- 0.000 | 4.110<br>4.080 |      |                  |
| 4       | Spacer      | 0.025inches $\pm$ 0.010        | 0.035<br>0.015 |      |                  |
| 5       | Spacer      | 45.0Degrees $\pm$ 0.5          | 45.5<br>44.5   |      |                  |

Plex 11/21/17 8:02 AM dart.lacelle.linda

**DART**  
AEROSPACE  
**S019147**



Spacer

**PART NO:**

**D3681 - 1**

**Revision:**

**Operation:**

**Change No:**

**Start up Operation**

**Dart Aerospace Ltd.**

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**Mfg Date: 12/08/17**  
**Job No: 168675**

